

# Work Order ID **77424**

Tuesday, December 06, 2011 2:19:31 PM

**\*77424\***

Page 1

Item ID: **D3684-047** Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: FWD LEG ASS'Y  
 Start Date: 12/6/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 12/9/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MF Date: 11-12-06 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	Rev D

100	Pick Kit	0.00
<b>*100*</b>		
Packaging	Memo	0.00
Packaging		

110	Small Fab	0.00
<b>*110*</b>		
Small Fab	Memo	0.00
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684	
	2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684	
	**Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3684	

*EPH/12/07 ①*

*EPH/12/08 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		Sub 12107		①			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <b>6A</b>  Memo	0.00  0.00							<b>EP 11/12/08 ①</b>
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<b>11/12/08 ME 11-12-06</b>

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# Picklist Print

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Work Order ID: 77424

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y

Start Date: 12/6/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM  
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
 03-16 JLM VERIFIED BY:EC  
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD  
 IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			11G	Each	90.0000	2	2		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		90							
				117514		4							
				118112		5							
				118422		17							
				118451		22							
				119510		42							
D3688-1 STUD		Manufactured	No			110	Each	6.0000	1	1		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				72045		6							
D3689-1 SLEEVE		Manufactured	No			110	Each	11.0000	1	1		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		4							
				70858		4							
				ST075		7							
				72117		7							
D3691-1 STUD		Manufactured	No			110	Each	10.0000	1	1		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		10							
				62181		10							

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 77424

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y

Start Date: 12/6/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

**D3692-1**

SPACER

Manufactured No

110 Each 141.0000

4

4

Location

Loc Qty

Loc Code

ST075

141

51467

41

73232

100

4

*EP 11/12/07*

**D3693-1**

Rod End Bearing

Manufactured No

110 Each 8.9000

1

1

Location

Loc Qty

Loc Code

GA

8

50734

8

1

*EP 11/12/07*

**MS21043-3**

Nut

Purchased No

110 Each 856.0000

2

2

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

784

118077

1

118614

449

118686

104

119758

230

2

*EP 11/12/07*

**NAS509-12C**

Nuts

Purchased No

110 Each 14.0000

1

1

Location

Loc Qty

Loc Code

ST280

14

112453

14

1

*EP 11/12/07*

**NAS509L12C**

Nuts

Purchased No

110 Each 19.0000

1

1

Location

Loc Qty

Loc Code

ST279

19

112314

9

112828

10

1

*EP 11/12/07*

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Shop Packet Print

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

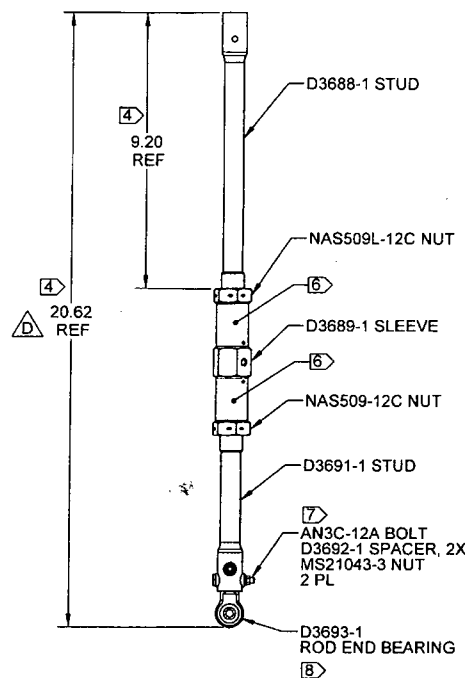
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-047 FWD LEG ASSEMBLY**



**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. D
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.03	DRAWING NO. <b>D3684</b>	SHEET 4 OF 5
		TITLE <b>TRIPOD MOUNT ASSY</b>	SCALE NTS
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**RELEASED**  
2010-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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